



NOTES:

1. MAKE FROM MDC'S DOUBLE SIDED VACUUM FLANGE CAT. #140030
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS	ANGLES			
.1	.03 [7620]			
.XX	.01 [0.25]			
.XXX	.005 [0.127]			
SURFACE ROUGHNESS				
125				
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ				
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 944				
POLISHING & TOLERANCES IN ACCORDANCE WITH LATEST ASST 944				
DO NOT SCALE DRAWING				
LOG NUMBER		A1433100		
DRAWN BY		DATE	CHEF DESIGN ENGINEER	DATE
MUSCIA		11/3/93	D. SHU	11/15/93
CHECKED BY		DATE	OP LEADER	DATE
J. WOTHE		11/15/93	M. KUZAY	11/15/93
DESIGNER		DATE	PROJECT MGR	DATE
SHU/MUSCIA		11/15/93		
RESPONSIBLE ENGINEER		DATE	APPROVE/RELEASED	DATE
D. SHU		11/15/93		
MATERIAL		SEE NOTE #1		
SCALE		HALF	SIZE	
SHEET		1 of 1	C	
DRAWING NUMBER		P4105090701-820001-00		